

# Work Order ID 58667

May 13, 2010 1:20:06 PM



Page 1

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 13/05/2010 Start Qty: 8.00

Required Date: 22/05/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference: *Ref 10-05-13*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *58667* Double check by: *B.A* 1-Machine Step No 1  
per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step  
No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine  
Step No 3 per Folio FA051 and inspect

*Ref 10-5-15*  
*B.A 10/05/18*

*8 0*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

*Ref 10-5-16*  
*B.A 10/05/18*

*8 0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*Ref 10-5-16*  
*B.A 10/05/18*

*8 0*

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Cust Item ID:

Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00



Hand Finish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:30pm

OVEN TEMPERATURE:

2:00pm

FINISH TIME:

320°F

10/05/19

8 0

8 BR 10-5-20

10/05/20

8 0

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Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 13/05/2010 Start Qty: 8.00



Required Date: 22/05/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 BR 10-5-20

170

Identify as per dwg & Stock Location: 433

0.00



Packaging

Memo

0.00

Packaging

10-5-20 8x30

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/25  
10-5-21  
(8)

# Picklist Print

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Page 1

Work Order ID: 58667

Parent Item: D2571

Parent Item Name: Saddle. Fwd Out 205

Comments: IPP: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated  
D2572 KJ

Start Date: 13/05/2010

Required Date: 22/05/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	18.0000	1			



Saddle Billet



*del 00.5.15*

Location	Loc Qty	Loc Code
MAT42	18	
46412	18	

8

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 58667
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.50	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.495	.495	.495	.495		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.506	.506	.506	.506		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.571	.571	.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.875	3.875	3.875		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.248	.248	.248	.248		
S	0.115	0.135		.129	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		.235	.235	.235	.235		
W	0.115	0.135		.129	.129	.129	.129		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.485	.485	.485	.485		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.375	1.395		1.387	1.387	1.387	1.387		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.245	.245	.245	.245		
AI	2.000	2.020		2.002	2.002	2.002	2.002		
AJ	0.023	0.043		.063	.063	.063	.063		
Accept/Reject									

Measured by: <i>MF</i>
Date: 10.5.16

Audited by: <i>MF</i>
Date: 10/05/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 58667
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.504	0.501	0.496	0.500		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.499	0.499	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.569	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.122	0.122	0.122	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.247	0.247	0.247	0.247		
S	0.115	0.135		0.117	0.117	0.123	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.232	0.231	0.232	0.234		
W	0.115	0.135		0.116	0.115	0.118	0.117		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.366	0.364	0.365	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.240	0.240	0.240	0.240		
AE	1.375	1.395		1.390	1.391	1.393	1.393		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.245	0.245	0.245	0.245		
AH	0.240	0.260		0.241	0.240	0.240	0.242		
AI	2.000	2.020		2.0024	2.002	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

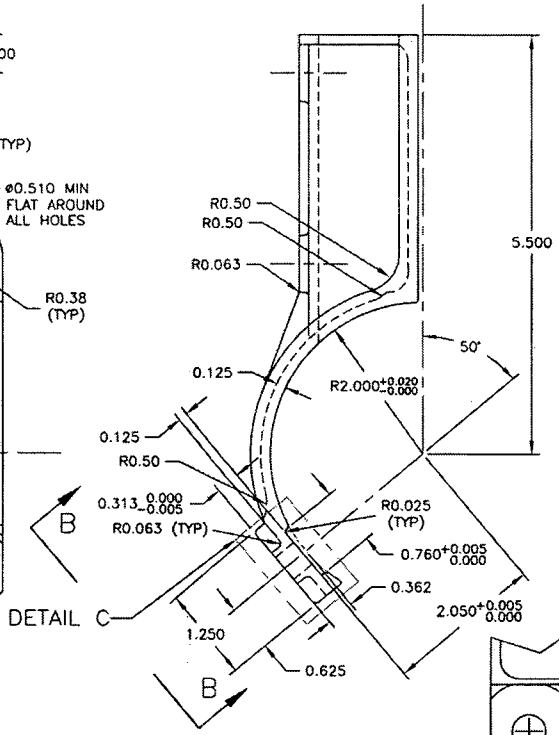
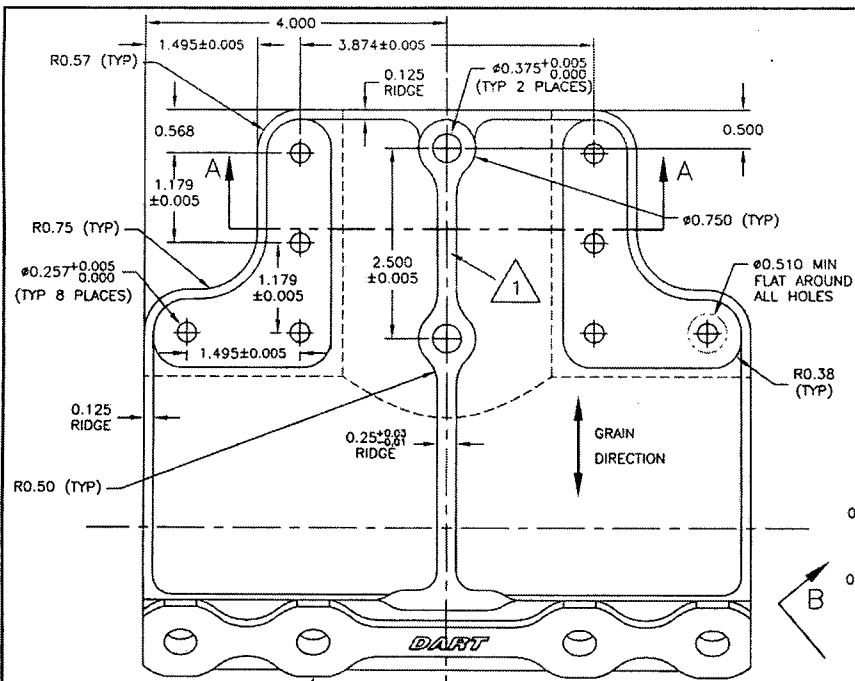
Measured by: K.A
Date: 10/05/18

Audited by: [Signature]
Date: 10/6/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

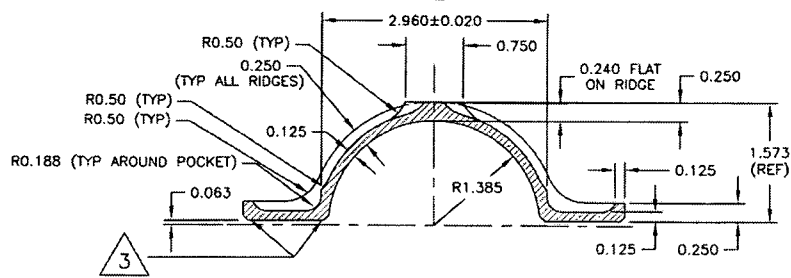
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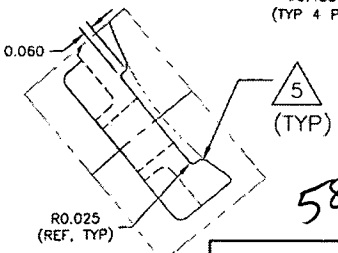
NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12) (REF DART SPEC. D6102-001)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

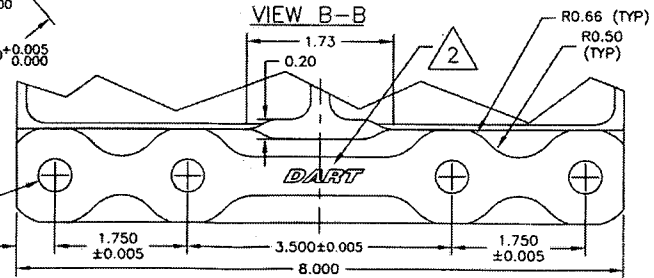
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)



SECTION A-A



DETAIL C  
 SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		OUTER FWD SADDLE

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**DART** DART AEROSPACE LTD.  
 MARKHAM, ONTARIO, CANADA  
 DRAWING NO. 02571  
 SHEET 1 OF 1  
 SCALE 2:3